

# Work Order ID 72729

Wednesday, August 10, 2011 8:23:13 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 8/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 11-08-10 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c/sink as per dwg

4- remove identification markings

5- deburr

SAD 11-08-17

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: *M117884*

7- grind weld flush

*Ac 11-08-24*

8- deburr if necessary

*Ppl 11-08-06*

*© Ppl 11-09-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/06

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/06

(76)

Quality Control

150

Identify as per dwg & Stock Location: WA 6

0.00



Packaging

Memo

0.00

8/11/06

(76)

Packaging

W/O:		WORK ORDER CHANGES					
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**Work Order ID 72729**

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Page 3

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Setup Start



Revision ID:

Stop



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Start Date: 8/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11  
MF  
11-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 10, 2011 8:23:19 AM

Page 1

Work Order ID: 72729

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 8/10/2011


Required Date: 8/16/2011

Start Qty: 6.00

Required Qty: 6.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1		Manufactured	No			100	Each	295.0000	3	18			
													
Bushing													

Location	Loc Qty	Loc Code
----------	---------	----------

WA	293	
69202	93	
72316	200	
WA005	2	
66489	2	

M304TS0.750W.065		Purchased	No			100	f	491.9380	8	50.52632			
													
304 SQ Tube .75x.75x.065W													

Location	Loc Qty	Loc Code
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MAT018	77.6987	
117636	77.6987	
WA	384.6276	
118181	384.6276	
WA007	29.6116906	
116267	23.018972	
116763	6.5927186	

11-08-23

18

SAD 11-08-23

50.5264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72729

*PL 11.08-10*

D3827-041 RIB ASSY (INBOARD)

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 4.59 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

RELEASED  
*08/10/13/W*

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>AB</i>		
APPROVED	<i>AK</i>		
DE APPR.			
DATE	08.09.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3827		REV. A	SHEET 1 OF 3
TITLE RIB ASSY (INBOARD)		SCALE	NTS
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W/O:		WORK ORDER CHANGES					
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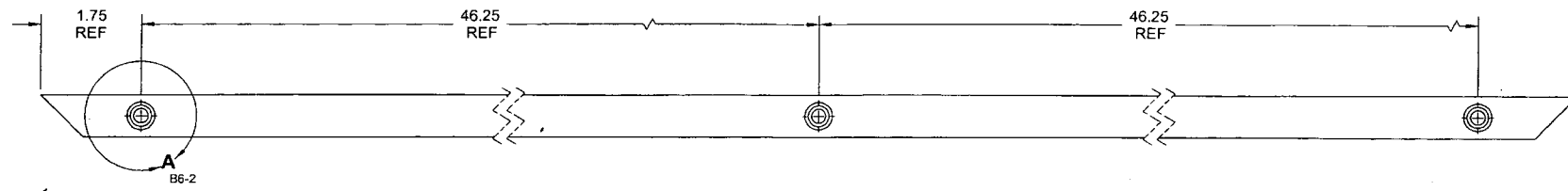
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

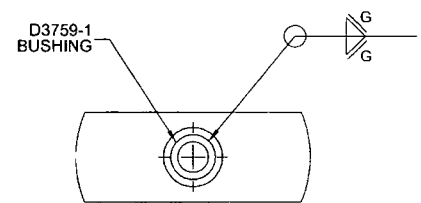
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**NOTE:** Date & initial all entries

72729



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
C7-2  
3 PL

**RELEASED**  
08/11/18/14/1

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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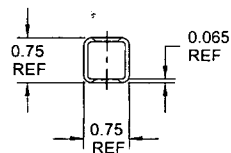
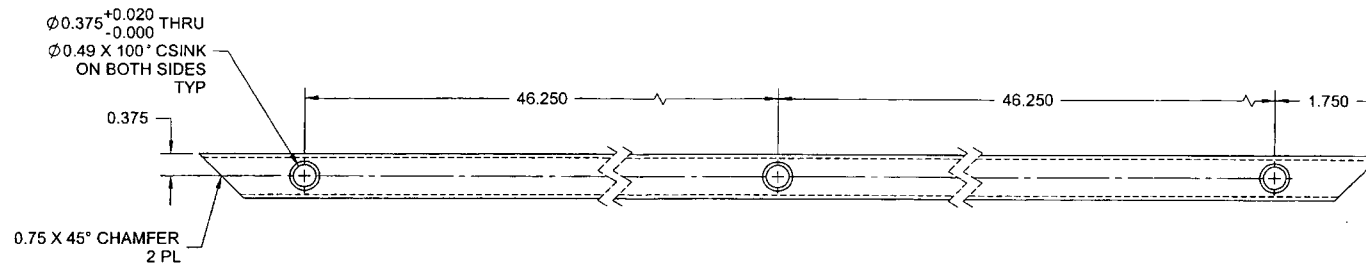
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12729



**D3827-1 RIB**

RELEASED  
08/11/12

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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